

**INSTRUCTIONS FOR VW CRANKSHAFT AND FLYWHEEL DRILL FIXTURE P/N 5004****FOR CRANKSHAFT:**

1. Screw the threaded insert on the end of the crankshaft.
2. Insert two of the stock dowel pins in the crank across from one another.
3. Place the large diameter of the fixture against the crankshaft with its two center holes on the dowel pins. Secure the fixture to the crank by placing the smaller diameter bolt through the fixture into the threaded insert already in the crankshaft and tighten.
4. Using a letter "O" drill start to drill a hole. This will make sure that the hole is centered. Finish drilling the hole with a letter "N" drill. (Your local tool store can supply letter size drills.)
5. Ream the hole to the finish size with a .3135 reamer. This will give a slight press fit on the pins. NOTE: Be sure to set the drillpress spindle stop to the correct depth so the dowel pins will set just below the top of the flywheel when installed. When using 3/4" long dowel pins the drilling depth in the crank is .550". Be sure to drill the original four holes deeper when using longer than stock pins. If the stock length dowel pin is retained drill the hole .425 deep.

**FOR FLYWHEEL:**

1. Install the drilling fixture on the flywheel with the smaller diameter of the tool going in the flywheel where the crank normally would. Use two dowel pins to locate the fixture properly. Secure the fixture to the flywheel with the special washer and larger diameter bolt supplies.  
**IMPORTANT:** Make sure that the two holes you select are not oversize or oblong. This will result in the pattern not being properly indexed causing the flywheel not to fit the crankshaft.
2. Using the letter "O" drill, drill the four additional dowel pin holes, then deburr with a chamfer tool.

**IMPORTANT NOTE:**

THIS DRILL FIXTURE HAS THE CUSTOMARY ONE HOLE OFFSET PATTERN.

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